

We Claim:

1. A process for preparing monoesters comprising the  
5 step of reacting at least one diol with at least one  
carboxylic acid in a biphasic solvent system, said  
carboxylic acid being sufficiently water soluble to allow  
esterification to occur, and said biphasic solvent system  
comprising water and at least one aprotic solvent in which  
10 the resulting monoester has greater solubility than in  
water.

2. The process of claim 1 wherein said diol is a  
diprimary or dissecondary diol.

15 3. The process of claim 2 wherein said diol is a  
diprimary diol.

4. The process of claim 1 wherein said diol is  
20 selected from the group consisting of 1,8-octanediol, 1,9-  
nonanediol, 1,10-decanediol, 1,11-undecanediol, 1,4-  
cyclohexanediol, and mixtures thereof.

25 5. The process of claim 4 wherein said diol is  
selected from the group consisting of 1,8-octanediol, 1,9-  
nonanediol, 1,11-undecanediol, and mixtures thereof.

6. The process of claim 1 wherein said diol comprises  
two hydroxyl groups having substantially equal reactivity.

30 7. The process of claim 1 wherein said diol is  
symmetric.

8. The process of claim 1 wherein said diol has less than about 14 carbon atoms.

5 9. The process of claim 1 wherein said carboxylic acid has a solubility in water of at least about 20% by weight at 20°C.

10 10. The process of claim 9 wherein said carboxylic acid has a solubility in water of at least about 50% by weight at 20°C.

15 11. The process of claim 10 wherein said carboxylic acid has a solubility in water of about 100% by weight at 20°C.

12. The process of claim 1 wherein said carboxylic acid has a solubility in water greater than or equal to that of isobutyric acid.

20 13. The process of claim 12 wherein said carboxylic acid is selected from the group consisting of formic acid, acetic acid, trifluoroacetic acid, *n*-butyric acid, pyruvic acid, propionic acid, and mixtures thereof.

25 14. The process of claim 13 wherein said carboxylic acid is selected from the group consisting of formic acid, acetic acid, and mixtures thereof.

30 15. The process of claim 14 wherein said carboxylic acid is acetic acid and the resulting monoester is a monoacetate.

16. The process of claim 15 further comprising the steps of:

(a) oxidizing the remaining hydroxyl group of said monoacetate to form an aldehyde, and

5 (b) reacting said aldehyde with an alkylidene phosphorane to form the corresponding olefinic monoacetate.

17. The process of claim 1 wherein said aprotic solvent has a polarity index between about 1.5 and about

10 3.5.

18. The process of claim 17 wherein said aprotic solvent has a polarity index between about 2.0 and about 3.0.

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19. The process of claim 1 wherein said aprotic solvent is an aromatic or ether solvent.

20 20. The process of claim 19 wherein said solvent is selected from the group consisting of toluene, benzene, chlorobenzene, ethylbenzene, xylenes, trifluorotoluene, dichlorobenzene, methyl tert-butyl ether (MTBE), diethyl ether, diisopropyl ether, dibutyl ether, and mixtures thereof.

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21. The process of claim 19 wherein said solvent is an aromatic solvent.

30 22. The process of claim 21 wherein said solvent is toluene.

23. The process of claim 1 wherein said diol and said carboxylic acid are reacted in the presence of an acid

catalyst.

24. The process of claim 23 wherein said catalyst is selected from the group consisting of sulfuric acid, nitric acid, hydrochloric acid, and mixtures thereof.